Date:

Friday, 6/1/2007 1:02:39 PM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 32742

Estimate Number P.O. Number

This Issue Prsht Rev. : 6/1/2007

S.O. No.

: 32270

: SMALL /MED FAB

Part Number **Drawing Number**

Drawing Name

: D353613 - D3536 REV A

: GASKET

: N/A Project Number **Drawing Revision**

Material : 6/8/2007 **Due Date**

20 Um: Qty:

Each

Written By

First Issue

Previous Run

Checked & Approved By

Comment

: Est Rev:A

New Issue 07-02-14 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

MNEO60S063

NEOPRENE SHEET 0.063



Comment: Qty.:

0.8682 sf(s)/Unit

Total: 17.3649 sf(s)

NEOPRENE SHEET 0,063

Batch: M103104

2.0



Comment: FLOW WATER JET

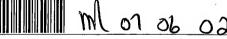
1-Cut as per Dwg D3536

Dwg Rev:__**y**-

Prog Rev:_

2-Deburr if necessary

3.0



INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

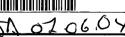




Comment: SECOND CHECK

5.0

PACKAGING RESOURCE #1



PACKAGING 1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		•		1					
				1					
· · · · · · · · · · · · · · · · · · ·									
				1					
				J					
				<u> </u>					

Part No:	 PAR #:	Fault Category:	NCR: Y	res No	DQA:	Date: 07/06/05
			Q	A: N/C C	osed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B			Approval Chief Eng	Approval QC Inspector		
DATE	STEP	Section A	Initial Action Description Sign & Date		Verification Section C					
		•		<u>-</u>		1				
		<i>Γ</i> .	-			1 2 - 4				
		·								
						1 .				
		•						•		
						1				

NOTE: Date & initial all entries

Date:

Friday, 6/1/2007 1:02:39 PM

Ušer:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 32742

Part Number: D353613

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CJ0706104

Dart Aerospace Ltd

W/O:		WORK ORDER CH	IANGES			1		
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
	,				e			
			*			:		
Part No	<u>.</u>	PAR #:Fault Category:	NC	R: Yes	No DQ	Δ.	Date:	<u> </u>

QA: N/C Closed: ____ Date: ___

NCR: WORK ORDER NON-CONFORMANCE (NCR)					ı	1		
		Description of NC	Corrective Action Section B			Verification	Annroyal	Ammenual
DATE	STEP	Section A	Initial Action Description Sign & Chief Eng Chief Eng Date		Section C	Approval Chief Eng	Approval QC Inspector	
		1 7	*					
						1.0		
		8.0						
		i !						
	:							:
						·		· · · · · ·
								7
						;		. 4
			1.0					

NOTE: Date & initial all entries

06.

.10.25

GASKET

 \triangleright

9

.10.25

NEW

ISSUE

CHECKED

APPROVED

 \mathcal{Z}

D3536

1 OF 6 SCALE 1:10

DRAWING NO

B

罗剌

DART

AEROSPACE PORT HADLOCK,

≸

JSV,

NC.

8 BELLIA. 11.20

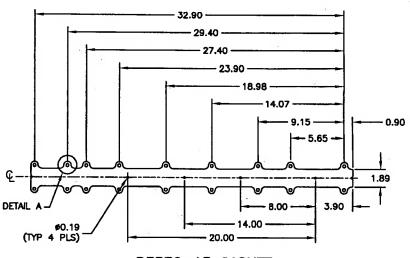
26.65 23.15 21.15 17.65 13.40 0.90 - 5.65 1.89 DETAIL A 3.90 Ø0.19 (TYP 3 PLS)

D3536-11 GASKET

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHO'JT NOTICE ENGINEERING SHOP COPY RETURN TO

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
 IDENTIFY WITH DART P/N USING A WHITE FINE POINT
 PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-13 GASKET

07.02.12

THE TO

DATE 06.10.25 CHECKED B \mathcal{Z}

D3536 DRAWING NO

GASKET

DART AEROSPACE PORT HADLOCK, USA, SHEET

₹ C.

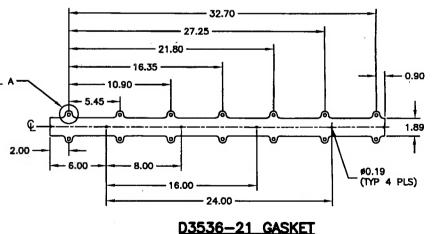
2 OF 6

35.65 - 30.15 -24.90 19.65 0.90 5.65 1.89 #0.19 (TYP 4 PLS) 3.90 DETAIL A 24.00

D3536-15 GASKET

UNCONTROLLED COPY SUBJECT TO AMENDMENT WORK ORDER WITHOUT NOTICE SHOP COPY ENGINEERING RETURN TO

- MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- PART IS SYMMETRICAL ABOUT ©
 TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



7) SEE PAGE 6 FOR DETAILS AND SECTION

Copyright COPRIVATE AND CONFIDENTIAL AND IS SUPPORTED TO ANY OTHER F ght © 2006 by DART AEROSPACE USA, III

OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART INC.

OT TO BE USED FOR ANY

T AEROSPACE USA, INC.

PURPOSE

유

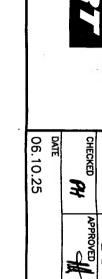
COPIED

됐

ಭ

DETAIL A





B GASKET D3536 DRAWING NO. DART AEROSPACE PORT HADLOCK. **USA**

SHEET

3 OF SCALE 1:10

NC.

52.85 21.20.10 48.20 28.53 23.14 -DETAIL A 2.00 1.89 6.00 0.90 - 16.00 **≠0.19** (TYP 6 PLS) 24.00 32.00 39.00 48.00

D3536-23 GASKET

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE SHOP COPY ENGINEERING RETURN TO

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

봀

DOCUMENT

Ŋ

Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

PURPOSE

욹

COPIED

2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
7) SEE PAGE 6 FOR DETAILS AND SECTION

RO.06 (TYP) RO.25 TOOLING NOTCH (TYP)	21.80 16.35 10.90 5.45 1.89 6.00 1.89
	#0.19 (TYP 3 PLS)

D3536-25 GASKET

DATE 06.10.25 CHECKED \mathcal{Z}

D3536 DRAWING NO. PORT HADLOCK,

GASKET

B DART

AEROSPACE ₹ USA, SHEET.

NO.

4 OF 6 SCALE 1:10

07.02.12 21.00 2.00 -6.00 1.89 6.00 6.75 DETAIL A

D3536-33 GASKET

#0.19 (TYP 3 PLS)

22.50 19.00 2.00 -6.00 -1.89 Q. DETAIL A #0.19 (TYP 3 PLS)

D3536-31 GASKET

UNCONTROLLED COPY SUBJECT TO AMENDMENT SHOP COPY ENGINEERING WITHOUT NOTICE RETURN TO WORK ORDER

뒾

DOCUMENT

Ñ

Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

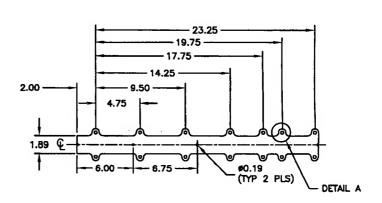
PURPOSE

유

COPIED

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-35 GASKET

AEROSPACE

NC.

5 9 SCALE 1:10

06.10.25

GASKET

7.02.12

2.00 1.89 E 6.00 16.00 DETAIL A 21.00 #0.19 (TYP 4 PLS) D3536-37 GASKET

22.50

30.75 27.25

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE SHOP COPY ENGINEERING RETURN TO

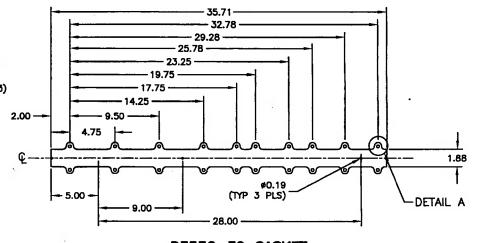
1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-39 GASKET

S	
DCU ₁	
PEN T	l
<u>v</u>	l
O X	
₽Ħ S≯	l
N C	l
NON E	l
DE C	
3 ₹ 8	ļ
₹ 3	l
HE SE	
PP N	
RS E S	
2 5 E	
から	ı
Copyright © 2006 by DART AEROSPACE USA, INC. BENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE ED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AERO	١
B SS ≥	l
	l
₽₹ S	
ڳ≒ڳ	
Ø Z ≯	
## ₹	
SOS P	l
SS A	l
Copyright © 2006 by DART AEROSPACE USA, INC. INVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR AN OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	ĺ
R NC ≱	
~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~	
Copyright © 2006 by DART AEROSPACE USA, INC.  S DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
380	
မ္က	ı

봀

07.62.12

C B	CB	DART AEROSPACE USA, INC.
CHECKED	APPROVED ///	DRAWING NO. REV. A
#	#	D3536 SHEET 6 OF 6
DATE		TITLE SCALE
06.10.25		GASKET 1:10

27.98 25.08 15.00 2.00 -1.88 4.00 #0.19 (TYP 2 PLS) 3.90 DETAIL A

### D3536-41 GASKET

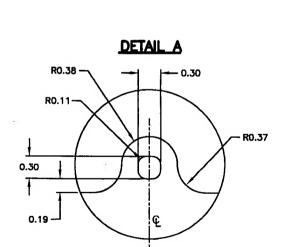
SHOP COPY

RETURN TO

RETURN TO

RETURN TO

ONTROLLED CONTROLLED C



	SA SA	
	COA	
	₩Q Q	
ı	Z Ž	δ
	≥ ≥	ड्रॅ
١	35	츛
	표원	
١		22
ı	S S	8
ı	₹Z	इ
	Sm Sm	8
١	¥R R R	4
ł	E S	A
l		졄
ļ	SSI	¥
ı	N Z Z	R
l	8 ⊒	Copyright @ 2006 by DART AEROSPACE USA, INC.
ı	DAR.	>
I	걸	롱
ı	SP R	•
l	ACE ESE	
I	PS FO	
I	RYMATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
	<b>₹</b>	
I	RIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
ı	SE C	

유 COPIED

붚

DOCUMENT

ឆ ヌ

DART AEROSPACE LTD	Work Order: 32142
Description: Grabet	Part Number: D3536-13
Inspection Dwg: D3536 Rev: A	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

		***************************************	,
X	First Article	Prototy	Эе
L			

ln: Dra	spection Sheet wing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	32,90	H-0.030	32.90	$\checkmark$	, v	Me-t	1
В	0.301 0.30	+1-0.030	031000.310			Yern	
С	1.89	+1-0.030		<b>V</b>		JWW	
Đ	Ø 0.19	+1-0.030	0.20	$\sqrt{}$		vern	
E							
F-							
G							
} <u>{</u>							· · · · · · · · · · · · · · · · · · ·
· ·							
J							
K							
<u> </u>				-			
M							
N							
0							
Р						,	
Q							
R			'				
S	,						
T							
U							
٧	1						
W							
X							
Y							

Measured I	by:	M. W	Audited by:	20	Prototype Approval:	N/A
Date:	te:	070602	Date:	01.06.04	Date:	N/A
Rev Date		Change		Revised by	Approved	
1	7	New Issue			KJ/RF	

